5/26

DART AEROSPACE LTD	Work Order:	23641
Description: Saddle Billet (6061)	Part Number:	D6102-010
04.09.09 ~~B~~ 04.09.09		
Dwg: D6102 Rev. ~~B~~ C	Qty:	3
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	U	05.06.21	3
2	PG	Issue P/O: 2008253 a) Description: Aluminum Billet b) 7.950" x 8.250" x 2.500" thick c) Tolerance on all dimensions is +0.06/0.00 d) Grain direction along 7.950" length e) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8) **Material release certificate is required**	U	05.06.21	3
3	RG	Receive and Inspect for transit damage **Ensure material release certificate is attached**	DL	05/06/27	3
4	QC6	Inspect dimensions as per Dwg D6102 **Check certificate to Dwg D6102 for compliance**		05/08/26	3
5	ST	Identify and Stock		05/08/26	3
6	AC	Cost / part: 97.66		05.08.29	3
7	DC	Close W/O 90, 36 Inspect Level 21		05/08/29	3

Rev	Date	Change	Revised By	Approved
A	04.08.19	New issue	KJ/JLM	

RELEASED 04.08.19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: ________ **PAR #:** ________ **Fault Category:** ________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 05/08/29

NOTE: Date & initial all entries **QA: N/C Closed:** ________ **Date:** ________

H:\forms\Quality Assurance\approved forms\NCRWO revC

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D6102 — Rev. C — SHEET 1 OF 1
DATE 04.08.25		TITLE SADDLE BILLET, 6061 — SCALE NTS

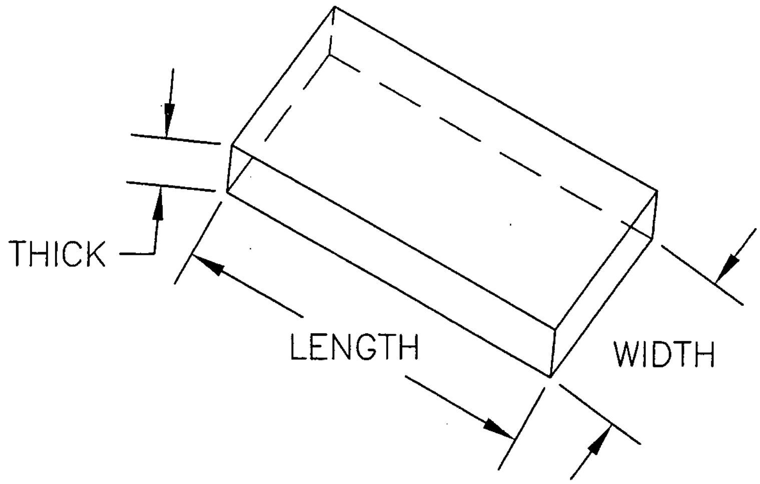
A	01.03.30	NEW ISSUE
B	03.10.20	ADD D6102-005/-007/-009
C	04.08.25	ADD D6102-010/-011

DART

QA COPY ISSUED

RELEASED 04.09.04

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 23641

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6102-001	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.880	6.250	2.000	Along 7.880 Length
D6102-003	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.000	6.250	2.000	Along 6.000 Length
D6102-005	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	47.85	15.250	1.000	Along 47.85 Length
D6102-007	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.500	7.000	2.500	Along 7.500 Length
D6102-009	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	11.000	6.000	5.000	Along 11.000 Length
D6102-010	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.950	8.250	2.500	Along 7.950 Length
D6102-011	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	8.250	2.500	Along 6.500 Length

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 21, 2005
01:04 pm

Work Order No	: 0023641			
Project Name	: D6102-010		Department Code:	
Project For	: WK526		Burden Flags	: NNNNNNN
Work Order Type	: Main		WO Status	: Open
Main WO Number	:		Invoice State	: Not Invoiced
House Part Number	: D6102-010		Invoice Date	:
Description	: 6061-T6 8.25x7.95x2.5		Invoice Number	:
Manufactured	: Yes		Invoice Amount	: 0.00
Amount Req'd	: 3			
Amount Done	: 0		Order Entry No	:
Start Date	: 06-21-05		OE Value	: 0.00
Est Finish Date	: 06-30-05			
Act Finish Date	:		Est Mark Up	: 0.000%
Drawings Reqd	: No		Actual Mark Up	: 0.000%
Ok for Approval	:			
Approval Rec'd	:		$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

CERTIFICATION
SOLD TO:
DATE:
CUSTOMER P.O:
CUSTOMER PN:
ATTN:
QUANTITY:
BY:
THYSSEN COPPER & BRASS SALES INC

S.C. ALPROM S.A. SLATINA	CERTIFIED SRAC-IQNet ISO 9001/2000 No. 23/2-2002	MILL CERTIFICATE	EN 10204 3.1.B	No. 709

CUSTOMER : COMMONWEALTH METALS

CONTRACT/ORDER : 7313-14703-09
BILL OF DELIVERY : 64576
TRUCK/CONTAINER : ZCSU 2264039

ALUMINUM PRODUCTS-SHIPMENT OF40,315.255 LBS ALUMINUM PLATES 6061-T651, MILL FINISH, ACCORDING TO ASTM B-209,AMS 4027,AMS-QQA 250/11 TO BALTIMORE,MD.
LETTER OF CREDIT NUMBER I18572/214548.SHIPMENT FROM CONSTANTA ROMANIA TO BALTIMORE,MD.
BUYERS CONTRACT NUMBER 7313-14703-09. SHIPPING TERMS:CFR BALTIMORE,MD.

MATERIAL : ALUMINUM PLATES
ALLOY : 6061 TEMPER: T651
DIMENSIONS (mm) : CH007/2 - . 2.5000"THX60.50"WDX144.50"LT
CH018/1 - . 3.2500"THX60.50"WDX144.50"LT

ACCORDING TO : ASTM B-209,AMS 4027,AMS-QQA 250/11

MECHANICAL PROPERTIES 1 MPa = 1 N/mm2 = 0.145 ksi = 0.102 kgf/mm2

1 lbs = 0.4536 kg

			UTS ksi		YTS ksi		Elong. % 50mm	Hardness HB
			min.	max.	min.	max.	min.	min.
		Specified values:	42		35		6	
LOT	CASE	NET WEIGHT lbs	Measured values:					
CH007/2 - .	1	4,442.240	46.6		43.7		12	
			46.9		44.2		11	
CH018/1 - .	5	2,962.963	47.8		42.1		9	
			48.2		43		9	

CHEMICAL COMPOSITION %

BATCH	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ni	Ti	Al
CH007/2	0.71	0.47	0.22	0.12	1.08	0.072	0.016	0.006	0.022	REM.
CH018/1	0.69	0.41	0.24	0.071	1.13	0.057	0.02	0.005	0.017	REM.
Min.	0.4		0.15		0.8	0.04				REM.
Max.	0.8	0.7	0.4	0.15	1.2	0.35	0.25	0.05	0.15	

Cond. Others Each: 0.05 OthersTotal: 0.15

REMARKS: MAY 10 2005

We hereby certify that the material detailed hereon has been produced and tested according to the requirements of the relevant specification and/or order. Keep in dry conditions, without larges temperatures variations.

Date: QUALITY CONTROL DEPT.
2/9/2005

S.C. ALPROM S.A.

S.C. ALPROM S.A. C.T.C.